

Date: Monday, 11/6/2006 2:39:39 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 29337	
Estimate Number : 10315	
P.O. Number : <i>N/A</i>	Part Number : D265635
This Issue : 11/6/2006	Drawing Number : D2656 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i>	Drawing Revision : D
Previous Run : 29039	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 11/22/2006
Checked & Approved By : <i>[Signature]</i> 06 11 07	Qty : <i>53</i> Um : Each
Comment : Est: D 02.10.25 Re-format KJ/RF Est Rev:E Now on Waterjet 06-08-29 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S20GA	1010/1025/A21/6aA SHEET



Comment: Qty.: 0.3750 sf(s)/Unit Total: 18.7500 sf(s)
1010/1025/A21/6aA SHEET
20 GAUGE .040" THK
Batch: *M103258* *ml 02 02 02*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

SAD 07/02/04 *(53)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/02/03 *(53)*

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

07/02/05 *(53)*

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
1-Deburr if necessary
2-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326.
3-Identify as D2656-35.

SB 07/02/07 *(53)*
07/02/05 *(53)*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: ED Date: 8/10/10

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:39:39 PM
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Process Sheet

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Drawing Name: WEARPLATE

Job Number: 29337

Part Number: D265635

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



07-02-08 (53)



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



N/101601



(53x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-R/K

07/02/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/02/08 (53)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP21*

07/02/08 x 53

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(53)

Comment: FINAL INSPECTION/W/O RELEASE

07/02/12

Job Completion



07/02/09

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

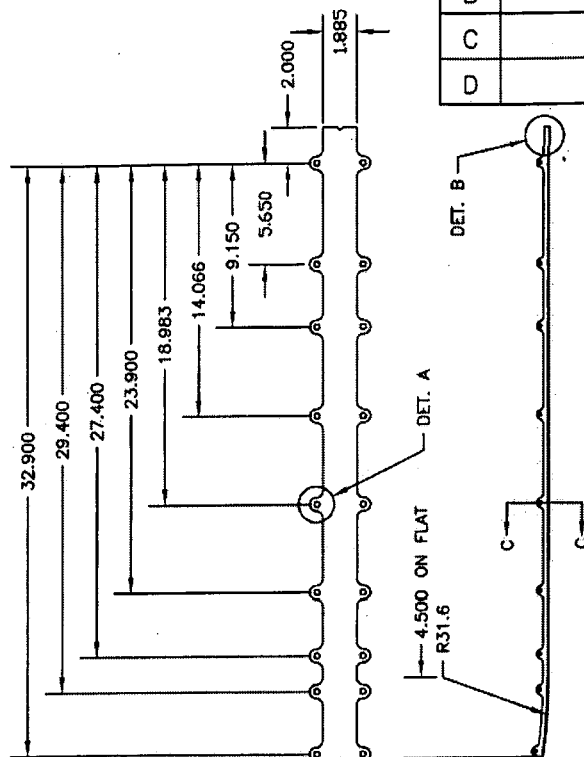
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

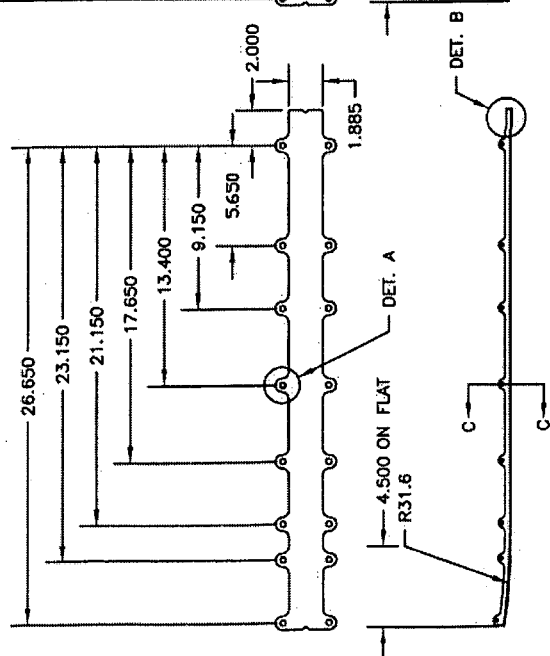


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				PORT HADLOCK, WA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2656
				REV. D SHEET 1 OF 4
DATE	05.08.17	TITLE	WEARSHOE	SCALE 1:10
A	97:03:25	NEW ISSUE		
B	97:06:02	CHANGED TABS		
C	97:06:26	R31.6 WAS R19.5		
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT		

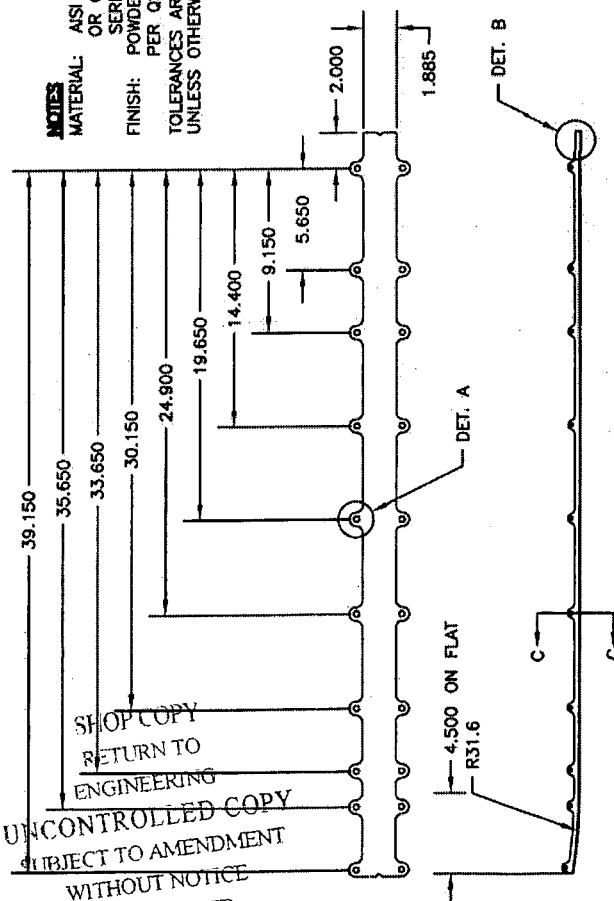
D2656-13



D2656-11



D2656-15



NOTES:
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 39W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
05.09.08

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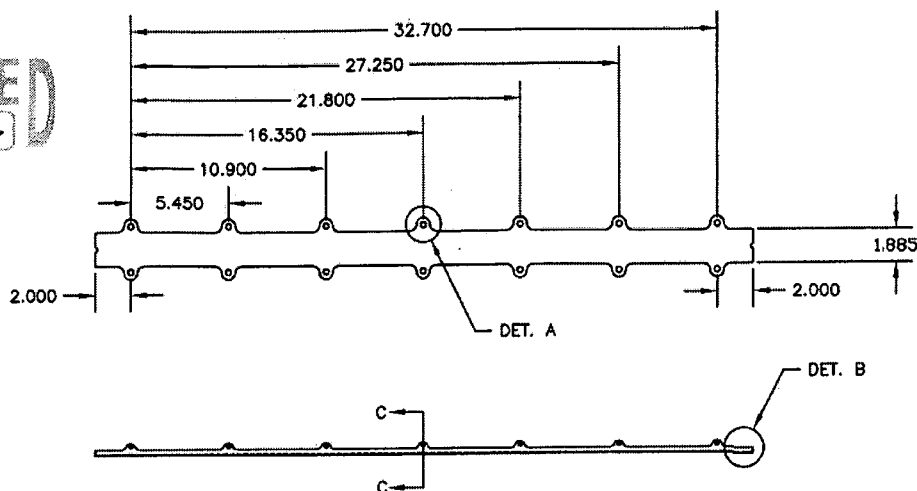
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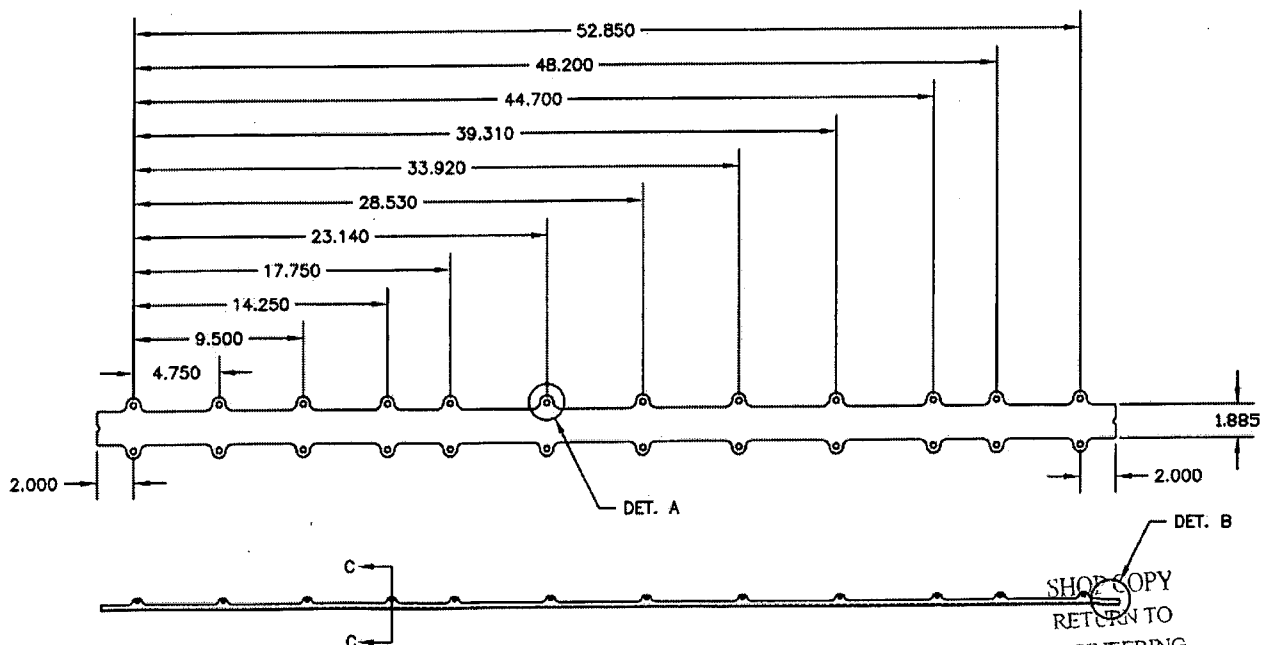
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D SHEET 2 OF 4
DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

RELEASED
05.07.06

D2656-21



D2856-23



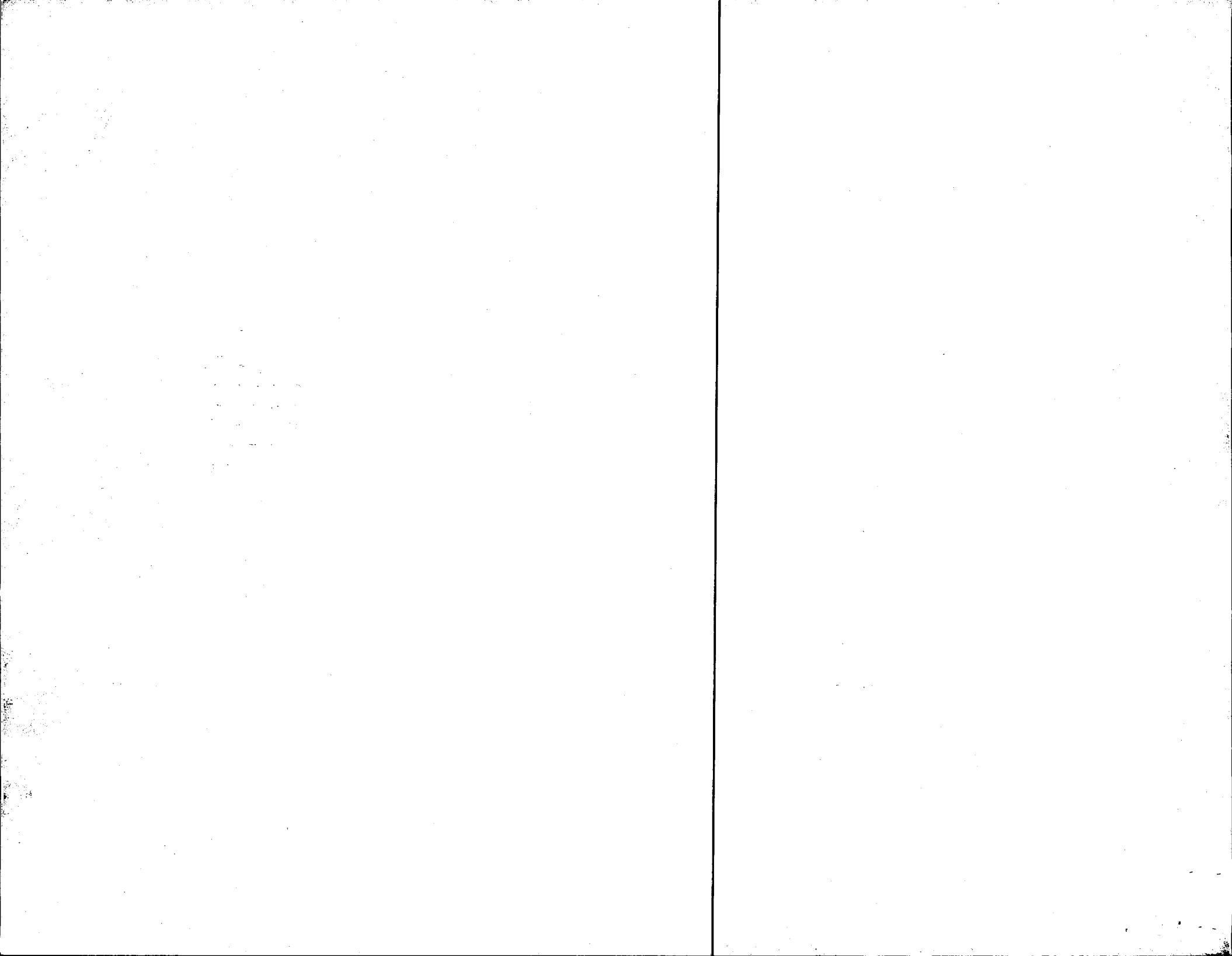
NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
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TOLERANCES ARE PER DART QSI 018
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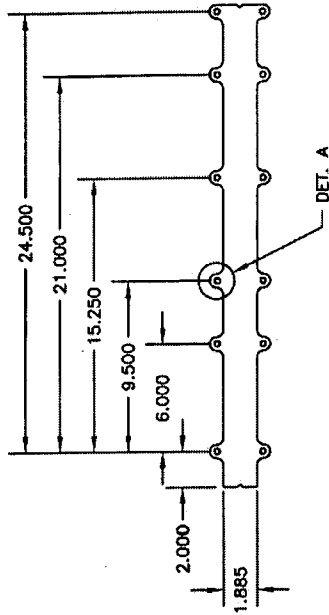
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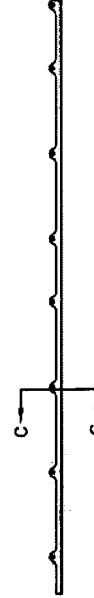
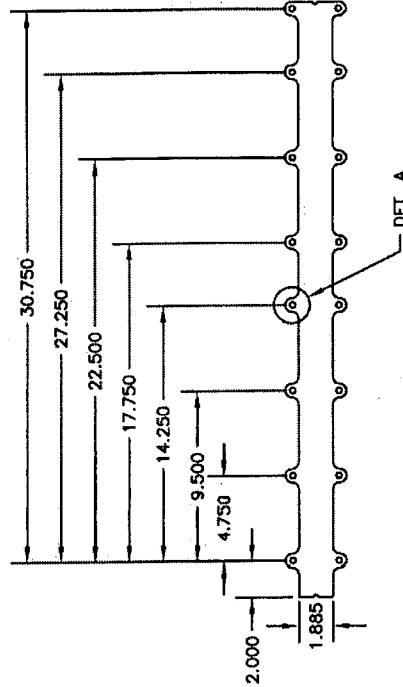


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CHECKED #	APPROVED #	DRAWING NO. D2656	REV. D SHEET 3 OF 4
DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

D2656-33

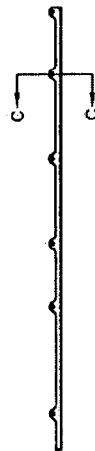
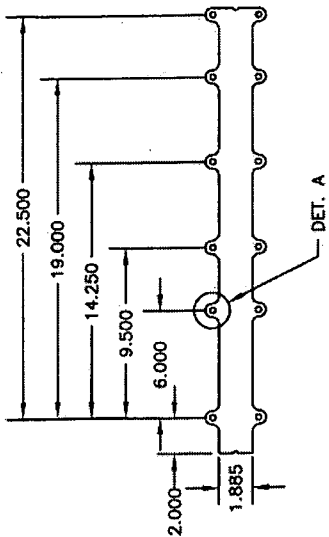


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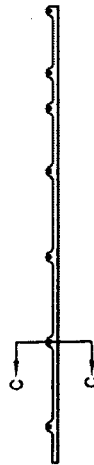
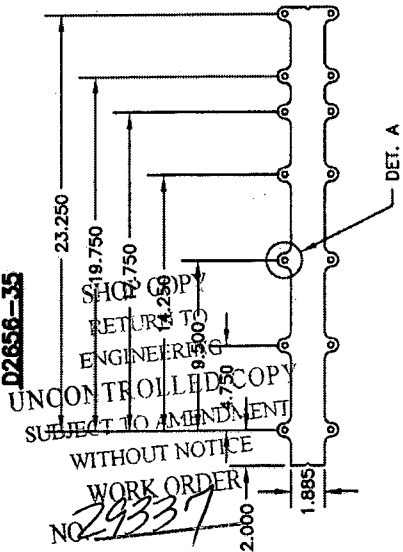


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D2656-31



D2656-35



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MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER QSI 018
UNLESS OTHERWISE NOTED

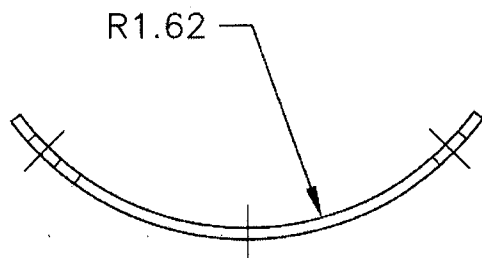
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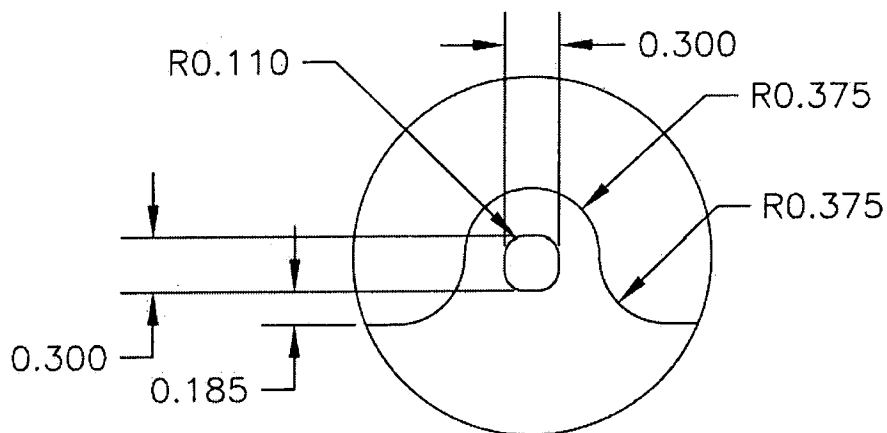
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

SECTION C-C

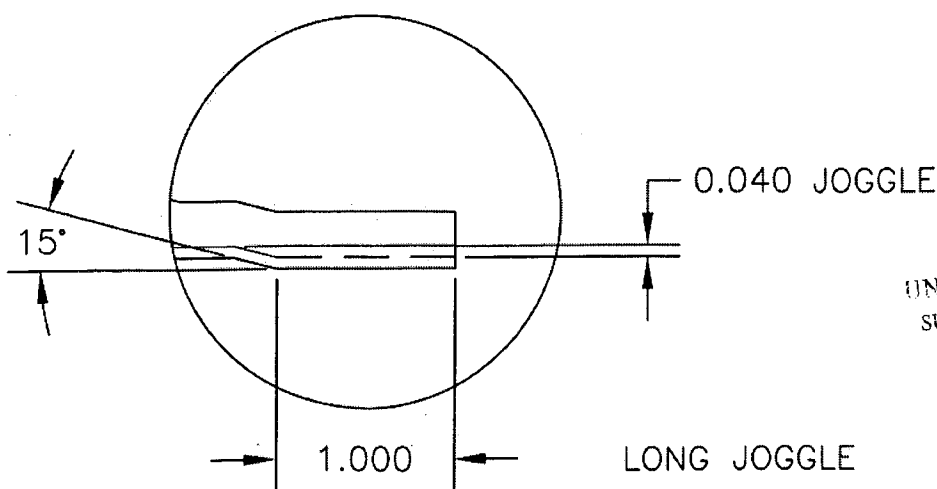


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DETAIL A



DETAIL B



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DART AEROSPACE LTD		Work Order:	2A 337
Description:		Part Number:	D2656 35
Inspection Dwg:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

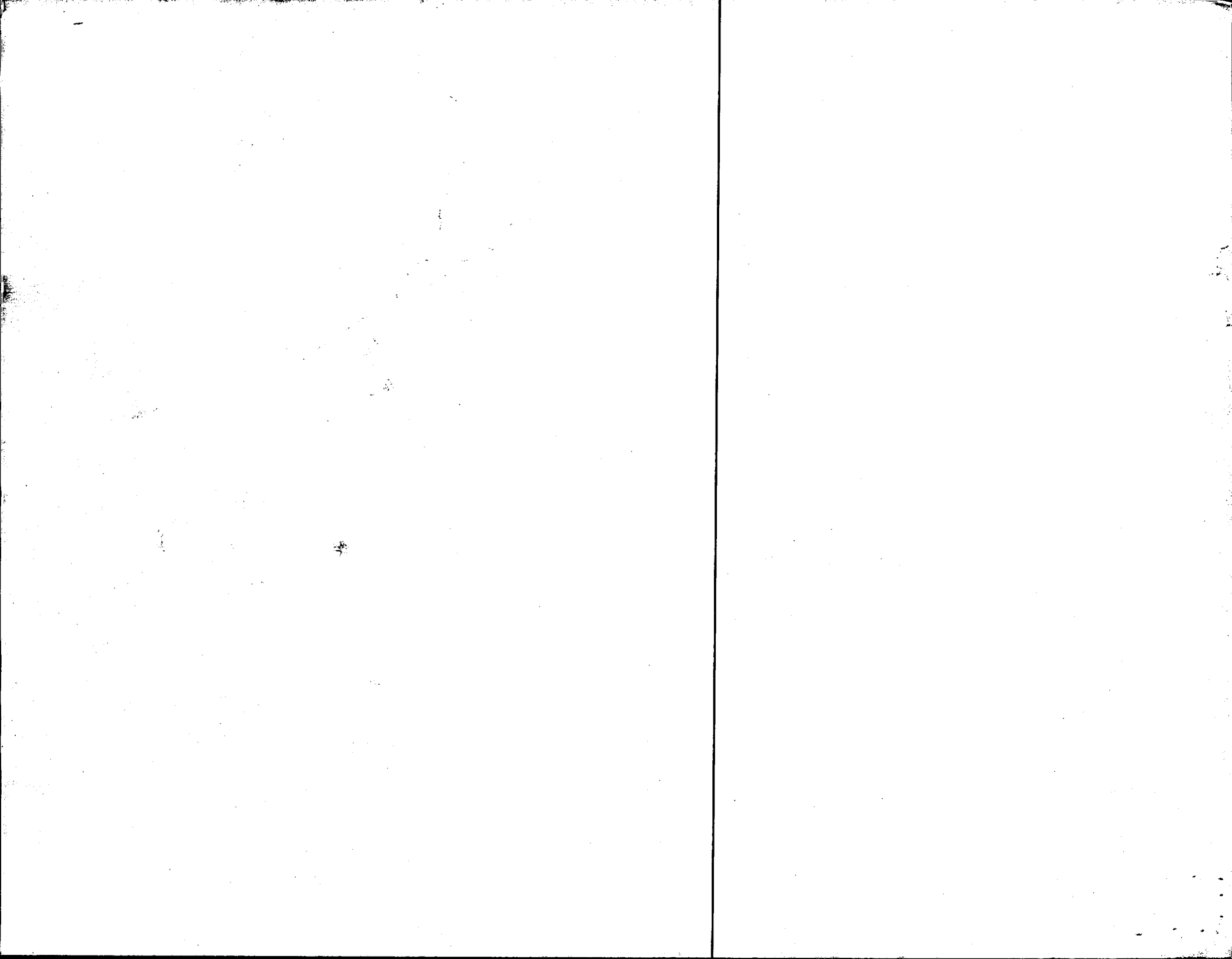
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[illegible]

Measured by: SAD	Audited by: 	Prototype Approval: 
Date: 07/01/03	Date: 07/02/05	Date: 

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



Jason Murdoch

From: S Shahbazian [sshahbazian@dartaero.com]
Sent: Thursday, January 25, 2007 8:20 AM
To: 'L Lacelle'; '*David Shepherd (*David Shepherd)'; 'Peter Hum (Peter Hum)'
Cc: 'Jason Murdoch'
Subject: RE: 1010 STEEL FOR WEARPLATES

I don't see problem of using .029 thicknesses instead of .036 for wearplates, unless David sees a problem.

Thanks
Serge

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: January 25, 2007 8:17 AM
To: 'S Shahbazian'; '*David Shepherd (*David Shepherd)'; 'Peter Hum (Peter Hum)'
Cc: 'Jason Murdoch'
Subject: RE: 1010 STEEL FOR WEARPLATES

Any news on this??

From: S Shahbazian [mailto:sshahbazian@dartaero.com]
Sent: January 23, 2007 4:51 PM
To: 'L Lacelle'; '*David Shepherd (*David Shepherd)'; 'Peter Hum (Peter Hum)'
Cc: 'Jason Murdoch'
Subject: RE: 1010 STEEL FOR WEARPLATES

Linda,

Do we know all the variable sizes that those sheets are coming in? The decision to accept the various thicknesses is depending on where the sheets are used. For example in this case it is used for wearplates which I think it is ok; however we have to see where else it will be used. In other words depends on the application.

Thanks
Serge

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: January 23, 2007 10:48 AM
To: *David Shepherd (*David Shepherd); S Shahbazian; Peter Hum (Peter Hum)
Cc: Jason Murdoch
Subject: 1010 STEEL FOR WEARPLATES

We are getting a lot of variances in tolerances on the steel mat'l we purchase for wearplates. Is there a standard tolerance for this mat'l? the 20ga we just rec'd should be about .036 – but we are getting .029 – is this acceptable. We have had this discussion before, but no one came back with a tolerance we can use to check this mat'l. Can anyone help?
LL

